Qty:

Date

Friday, 04/04/2008 9:21:56 AM

User:

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number **Estimate Number**

: 38391 : 10175

P.O. Number

This Issue : 04/04/2008

: NC

First Issue : //

: 37920

Type : MACHINED PARTS **Part Number**

Drawing Name

: D2570

Drawing Number

: D2570 REV B : N/A

: BUSHING

Project Number Drawing Revision

: B Material

Due Date

: 30/04/2008

Written By

Previous Run

Prsht Rev.

Checked & Approved By Comment

: Est E 02.08.29

Re-format; Removed finishing; Material change K

est F 07.07.06

rev B dwg

EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

2.0

3.0

M303R0750

303 Round Bar .75"

0.0810 f(s)/Unit Total:

40.4775 f(s) M 105710

Material: Ø0.750 AISI 303 SS Rod (M303R0.750)

Batch M107514 & (277 HARDINGE



Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198

Deburr

QC2





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



Comment: SECOND CHECK

PACKÂGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1 Identify and Stock

Location:



Dart Ae	rospace L	.td							
W/O:			V	VORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				*					:
· · · · · · · · · · · · · · · · · · ·									
Part No	:	PAR #:	Fault Ca	tegory: NC	R: Yes	No DQ	A:	_ Date: _	
					QA: N	I/C Close	d:	Date: _	
NCR:		V	VORK OR	DER NON-CONFORMANCE	E (NCI	र)			
		Description of NC		Corrective Action Section B		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8	ign & Section C C		Chief Eng	QC Inspector

NOTE: Date & initial all entries

Date:

Friday, 04/04/2008 9:21:56 AM

User:

Julie Lecocq

Customer: CU-DAR001 Dart Helicopters Services

Process Sheet

Drawing Name: BUSHING

Job Number: 38391

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/21 A MF 08-04-18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospace	Ltd							
W/O:		, , , , , , , , , , , , , , , , , , , ,	WC	ORK ORDER CHANGE	S				
DATE	STEP			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		4							
			· 						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	:	Date:	
						I/C Closed:			
NCR:		-	WORK ORDI	ER NON-CONFORMAN	NCE (NCF	₹)			
		Description of NC Corrective Action Section B				Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38391	
Description: Bushing	Part Number:	D2570	
Inspection Dwg: D2570 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	80/'				
0.060	+/-0.005	106/"				
R0.010	+0.010/-0.000	B0,00"				
Ø0.425	+0.000/-0.002	Ø, 425"				
Ø0.257	+0.005/-0.000	Ø ,259"		7		
Ø0.750	+/-0.010	Ø, 745"				
0.030 x 20°	+/-0.010	,030×20°				
		-				
					.,	
				_		
			#A. 4 THAT			
		ž.				

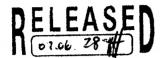
Measured by: 5, -	Audited by:	Prototype Approval:	N/A
Date: 08/04/15	Date: 08/04/5	Date:	

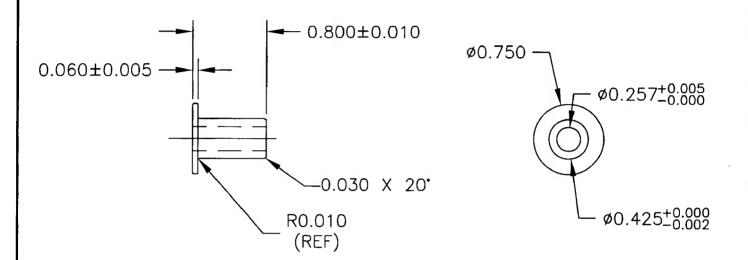
Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
С	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	E

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WITHOUT NOTICE
WORK ORDER
NO. 38394



DESIGN DRAWN BY PH PH			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHEC	KED ##	APPROVED	DRAWING NO.	REV. B		
	世	M	D2570	SHEET 1 OF 1		
DATE			TITLE	SCALE		
07.0)4.17		BUSHING	1:1		
Α		96.09.16	NEW ISSUE			
В		07.04.17	UPDATE NOTES			





D2570 BUSHING

D2570 BUSHING

MATERIAL: 1)

AISI 303 ROUND BAR (REF. DART SPEC. M303R)

2) FINISH: NONE

- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

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